Qty:

8 Um:

Each

: BRACKET

: D32111

: NIA

: 30/10/2006

: N/A

: D3211 REV A1

Date: User:

1 hursday, 26/10/2006 1:13:46 PM

Linda Lacelle

Process Sheet

Drawing Name

Part Number

Material

Due Date

Drawing Number

Project Number

Drawing Revision

Sustomer Job Number : CU-DAR001 Dart Helicopters Services

: 29014

Estimate Number

: 10710

P.O. Number

: NIA

This Issue

: 26/10/2006

S.O. No. : NIM

: NC Prsht Rev.

: NA First Issue

: 29014 **Previous Run**

Written By

Comment

Checked & Approved By

: MACHINED PARTS Type

New Issue 05-11-17 JLM Est Rev:B Now on Waterjet 06-10-24 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

M2024T3S063 1.0

2024-T3 .063 sheet

Comment: Qty.:

1.4753 sf(s)/Unit Total: 11.8020 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.063" thick

(M2024T3S.063)Identify as D3211-1

Batch: M101022

2.0

WATER JET

Comment: FLOW WATER JET

1-Cut as per Dwg D3211

Dwg Rev: AL

Prog Rev: A 1

2-Deburr if necessary

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE





PARTS AS THEY COME OFF MACHINE



4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr





· · · · · · · · · · · · · · · · · · ·	ursday, 26/10/2006 1:13:46 PM			
Uşer: Line	da Lacelle	Process Sheet		
Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name: BRACKET		
	00044	D. d. N b D22444		
Job Number	: 29014	Part Number: D32111		
Job Number:				
Seq. #:	Machine Or Operation:	Description :		
6.0	BRAKE NC	NC BRAKE	2 1000FF BEITT BB11 1001	
Comm	ent: NC BRAKE			,)
	Bend D3211-1 Stack as per Dwg D321	1	SB	06/11/16
7.0	QC5	INSPECT WORK TO CURRENT STEP		
Comm	ent: INSPECT WORK TO CURRENT STEP		14061	12 (8)
8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1		
. * - * - *				
Comm	ent: HAND FINISHING RESOURCE #1	11/ 12	1.100	0
	Chemical Conversion Coat as per QSI	005 4.1 H	6/11/22	X8
9.0	QC3	INSPECT POWDER COAT/CHEMICAL CON	VERSION	-
v.				
Comm	ent: INSPECT POWDER COAT/CHEMICAL	CONVERSION A, M,	06 11 22	R (8)
10.0	POWDER COATING	POWDER COATING		
Comm	ent: POWDER COATING		00 11 00	$\mathcal{L}(\mathcal{L})$
	Powder Coat Black Sandtex (Ref: 4.3.5		06 11 27	(8)
11.0	PACKAGING 1	PACKAGING RESOURCE #1		•
Comm	ent: PACKAGING RESOURCE #1			
	Identify and Stock Location: 5+ 59		6/4/2	3 8
12.0	QC21	FINAL INSPECTION/WO RELEASE		
Comm	ent: FINAL INSPECTION/W/O RELEASE			4/11/23
	1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1			
Job Completion			11 1	1011.73

Date:

Monday, 10/16/2006 2:01:44 PM

User:

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 29014

Estimate Number

: 10710

P.O. Number

: 10/16/2006 This Issue

Checked & Approved By

Prsht Rev.

Previous Run

Written By

Comment

: NC

First issue : 25252

: //

S.O. No. : Type

New issue

: MACHINED PARTS

05-11-17 JLM

Drawing Revision Material

Due Date

Drawing Name

Part Number

Drawing Number

Project Number

: BRACKET

: D32111

: N/A

: A1

: D3211 REV A1

: 10/30/2006

Qty:

8 Um:

Each

Additional Product

Job Number:



Seq. #:

1.0

Machine Or Operation:

: Est Rev:A

Description:

2024-T3 .063 sheet

1.4753 sf(s)/Unit Total: 11.8020 sf(s) Comment: Qty.:

Material: 2024-T3 (QQ-A-250/4) 0.063" thick (M2024T3S.063)Identify, as D3211-1

Batch:

M2024T3S063

2.0

SHEAR

SHEAR



Comment: SHEAR

Cut blanks: 17.800" x 11.375" (+0.000/-0.01%)

Grain along 11.375"

HAAS1 3.0

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3211-1 as per Folio FA348 and Dwg D3211

Stack of 4

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK





Page 1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No):	PAR #:	R: Yes	No DQA	ا: <u>ا</u>	Date: 🗘	×111/23	

QA: N/C Closed: _____ Date: _____

NCR:		V	VORK OR	DER NON-CONFORMANCE	(NCR)			
		Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
06/11/06	3	The programe was not good (Scrap 8)	opp	Nestroy and redo	M) B/11/06	06/11/00	ann	Bauss
					,			

NOTE: Date & initial all entries

Date:

Monday, 10/16/2006 2:01:44 PM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 29014

Part Number: D32111

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

BRAKE NO

NC BRAKE





Comment: NC BRAKE

QC5

Bend D3211-1 Stack as per Dwg D3211

8.0



INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0

POWDER COATING

POWDER COATING





Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

13.0 QC21

FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace Ltd

		·								
W/O:		·	WC	ORK ORDER CHA	NGES					
DATE	STEP	PRO	CEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									,	
Part No	:	PAR #:	Fault Cate	gory:	NCR					
				QA: N	/C Closed	:	_ Date: _			
NCR:		V	VORK ORDI	ER NON-CONFOR	RMANCE	(NCF	R)			
DATE	STEP	Description of NC Section A	Corrective Action Section Initial Action Description			Sign &	Verific		Approval	Approval QC Inspector
		Section A	Chief Eng	Chief Eng		Date	Section	on C	Chief Eng	QC Inspector
							2			
										-

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	29014
Description: Bracket	Part Number:	D3211-1
Inspection Dwg: D3211 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

		X First Artic	F	- 1	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Con	nments
R0.25	+/-0.030	RO.25			R-6-		
1.91	+/-0.030	1,912			Vern		
Ø0.128	+0.005/-0.000	80.127			Vern		
Ø0.141	+0.005/-0.000	00.140			Vern		
17.71	+/-0.030	17.71	\		The vice	are VO	<u> </u>
1.91	+/-0.030	1,917			Jern	A	
1.56	+/-0.030	1.567			Vern		
11.32	+/-0.030	11.33			Vern Vern		
			. -				
						-	

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	,						
,							
easured by:	SHD	Audited by:			Prototype A	proval:	N/A
Date:	76:11:05	Date:				Date:	N/A
ev Date	Change				Re	evised by	Approve
A 03.12.15	New Issue	P/O D350-567-0	15/-025/-0	31	K.	I/RF	1,14





		and the second second			
	DESIGN	a	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
/	CHECK	ED 🔏	APPROVED A	DRAWING NO.	REV. A
		M	1	D3211 SHEET	1 OF 2
	DATE			TITLE	SCALE
	03.0	9.03		BRACKET	1:3
	Α		03.09.03	NEW ISSUE	
	Ai	410	63. iZ. 05	CHANGE ALL BEND RAPH TO ROIZE	(

PER DRAWING FILE "D3211-A2.DWG"

MACHINE

FINISH: ACID ETCH

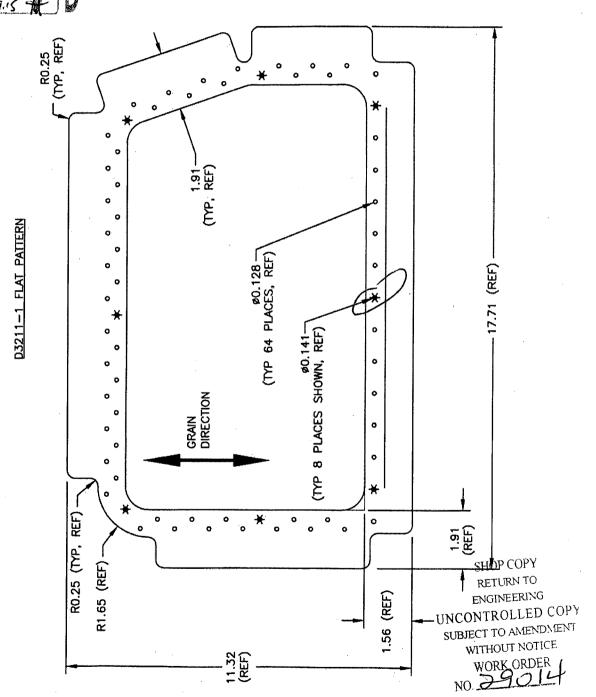
(REF) 9.50 90. 1.00 (TYP) 0 o 0 O 0 0 ٥ ٥ 0 0 RO.125 BEND RADIUS THIS EDGE ONLY 0 0 ٥ Q 15.89 0 0 0 SHOP COPY 0 RETURN TO ٥ ENGINEERING UNCONTROLLED COPY USE MINIMUM BEND RADIUS TOLERANCES ARE PER DART ٥ SUBJECT TO AMENDMENT o ٥ o 0 0 0 0





DESIGN	(P DR	AWN BY		OSPACE LTD ONTARIO, CANADA
CHECKED	AP AP	PROVED	DRAWING NO.	REV. A
DATE	711	9	D3211	SHEET 2 OF 2 SCALE
03.09.			BRACKET	1:3





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DART AEROSPACE LTD		Work Order:	29014
	33.4		- 00.1
Description: Bracket	* * * * * * * * * * * * * * * * * * * *	Part Number:	D3211-1
Inspection Dwg: D32(1.1) Rev:	14		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	FIRST ARTICLE INSPECTION CHECKLIST							
	x	First Arti	cle 📝	Prote	otype			
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection			
RO.25	H-0.030	RO.25	1		RADIUS GUA	ge		
1.91	41-0.030	1.916	1		VerN	9		
\$0.128	40.005-0.000	0.129	V		Vern			
Ø0.141	10.005-0.000	0.143	V		-VBFN			
17.71	+1-0.030	17.70	· V	<u> </u>	MEASURINE	Ape		
1.91	+1-0.030	1,918	V		very			
1.56	+1-0.030	1, 561	\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \		VerN			
11.32	H-0.030	11,305			vern			
						-		
				v		<u> </u>		
				7				
								
		Man 13						

Measured by:	M: M	Audited by:	Prototype Approval:	
Date:	06.11.07	Date: 06/11/07	Date: NH	
		V 1 1		

Rev	Date	Change	Revised by	Approved
Α		New Issue	KJ/JLM	L